

Date: Friday, 9/14/2007 2:00:49 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG	
Job Number : 34671A		
Estimate Number : 10839		
P.O. Number : N/A	Part Number : D22491	
This Issue : 9/14/2007 S.O. No. : N/A	Drawing Number : D2249 REV. E	
Prsht Rev. : NC	Project Number : N/A	
First Issue : N/A	Drawing Revision : E	
Previous Run : 34115	Material : N/A	
Written By : <u>JA 07.09.17</u>	Due Date : 10/20/2007	Qty: <u>30</u> Um: Each
Checked & Approved By : <u>JA 07.09.17</u>		
Comment : Est: D 05.02.04 Added Step 9 KJ/RF Est Rev:E Now on Waterjet 07-03-08 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0903 sf(s)/Unit Total : 0.9030 sf(s)

304/316 .063 Sheet

Batch: m10S130 IB 07-09-19

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2249

Dwg Rev: E IB 07-09-19

Prog Rev: E

2-Deburr if necessary

SAP 07/09/20

30 counted

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

IB 07/09/21 (735)

10 H1ED

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5122

07/21 (30)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 01/09/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/14/2007 2:00:49 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 34671A

Part Number: D22491

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

INSPECT PARTS AS THEY COME OFF MACHINE



final w/o inspection



(30)

Comment: ~~INSPECT PARTS AS THEY COME OFF MACHINE~~

Date 9/21

Job Completion



U 9/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

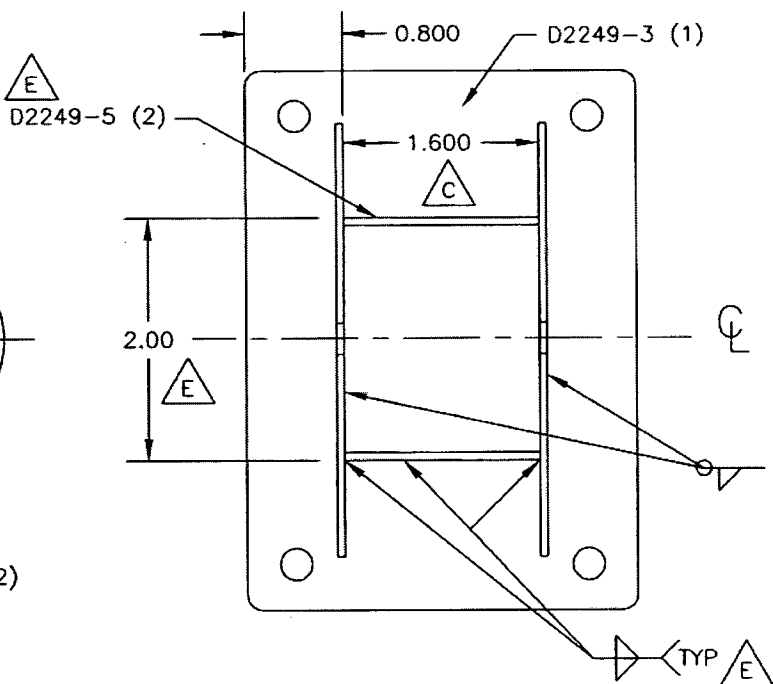
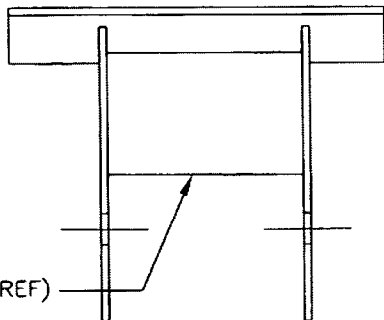
NOTE: Date & initial all entries

DART



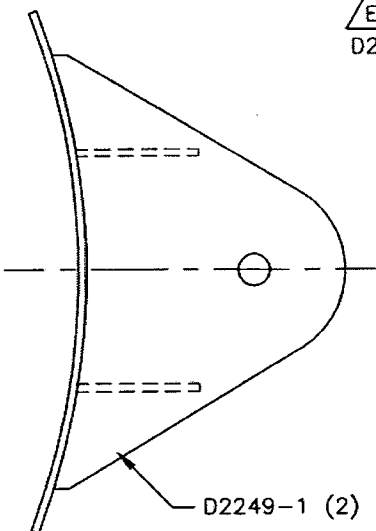
RELEASED
99.10.12 KCE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
AE	RF	CHECKED	APPROVED	REV. E
AE	RF	D2249	D2249	SHEET 1 OF 4
DATE		TITLE	SCALE	
99.09.20		FITTING	NIS	
A	94.06.20	NEW ISSUE		
B	95.11.30	DIMENSION CHANGE		
C	95.12.14	DIMENSION CHANGE		
D	98.04.30	Ø0.261 WAS Ø0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS		
E	99.09.20	ADDED GUSSET		



D2249-041 ASSEMBLY

MATERIAL: AISI 304/316 SS, 0.063 THICK
WELD PER DART QSI 004
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

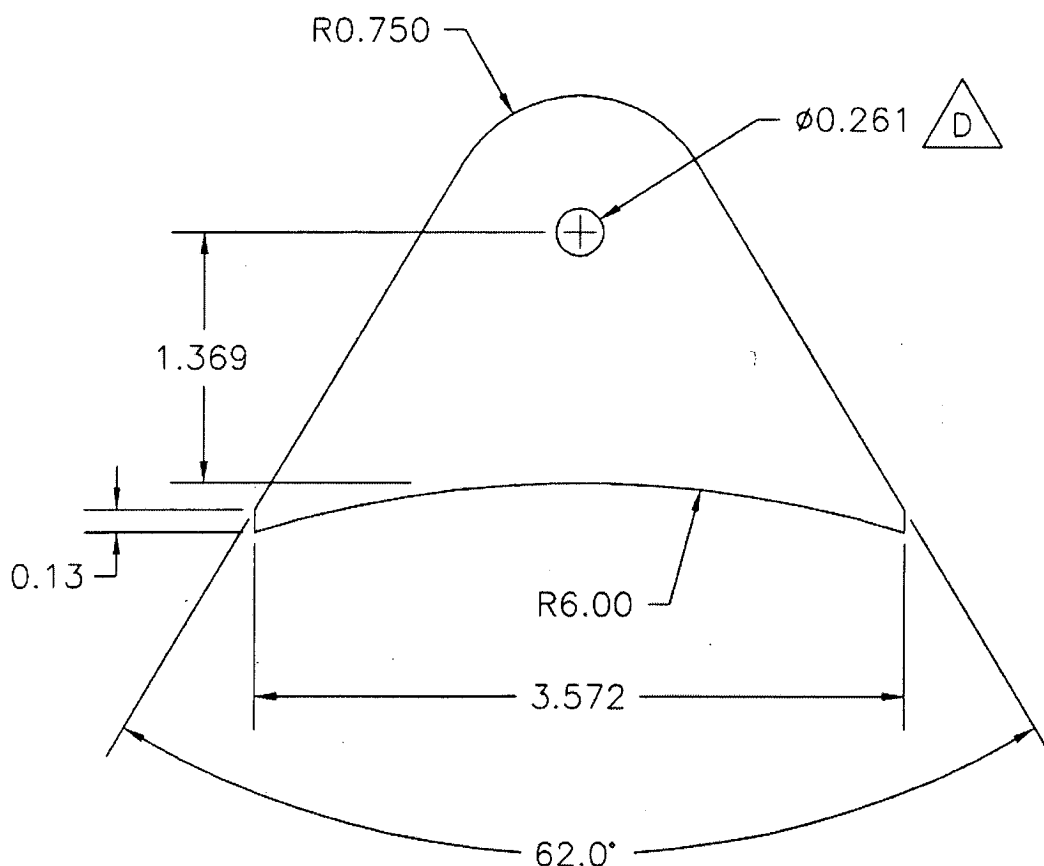


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WORK ORDER
NO. 34671A



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CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2249	REV. E SHEET 2 OF 4
DATE 99.09.20	TITLE FITTING		SCALE 1:1

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99.10.12 KE



D2249-1 LUG

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

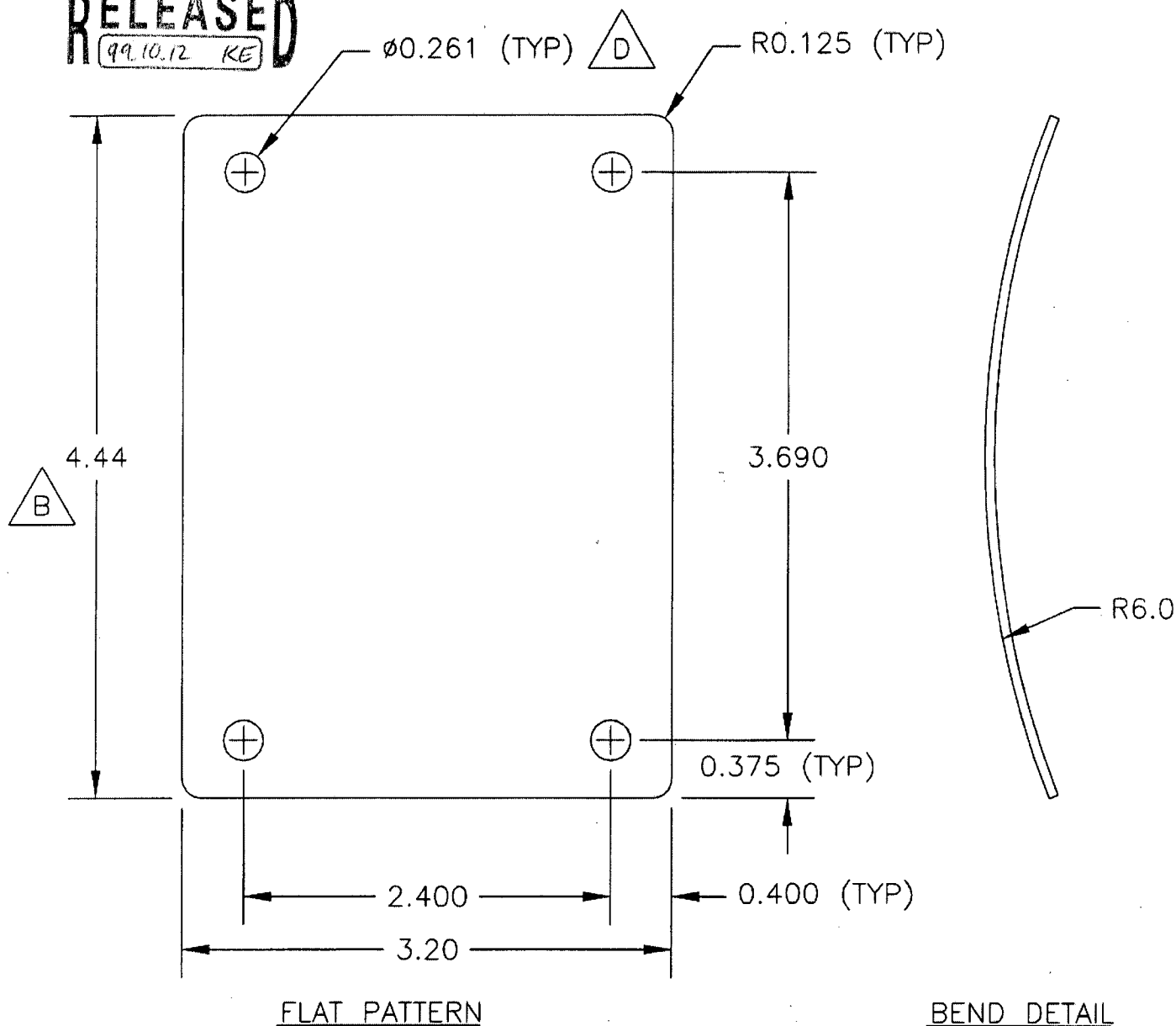
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DATE 99.09.20	TITLE FITTING		SCALE 1:1

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99.10.12 KE



FLAT PATTERN

BEND DETAIL

D2249-3 BASE PLATE

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

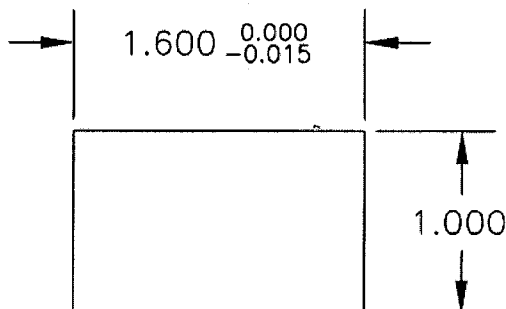
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DATE 99.09.20		TITLE FITTING	SCALE 1:1

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99.10.12 KE



D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK
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